



Leading Through Innovation



SOLID CARBIDE

DREAM DRILLS -INOX

DREAM DRILLS - INOX

- For Tough Materials like Stainless Steels
- Für schwierig zerspanbare Materialien wie Edelstahl

SELECTION GUIDE



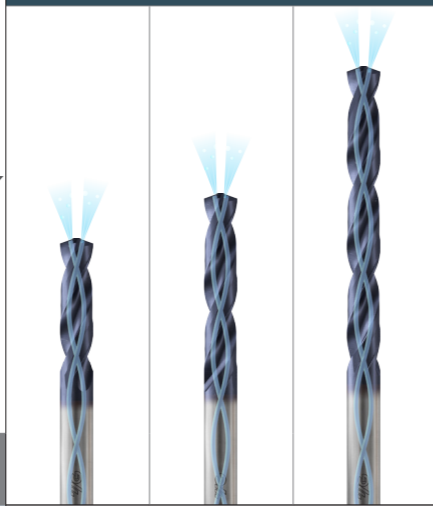
SERIES	DH451	DH452	DH453
DRILLING DEPTH	3XD	5XD	8XD
LENGTH	SHORT	LONG	EXTRA LONG
SIZE MIN	D3.0	D1.0	D3.0
SIZE MAX	D20.0	D20.0	D14.0
PAGE	A119	A122	A125

SURFACE TREATMENT

TiAIN

SOLID CARBIDE DREAM DRILLS INOX

For Tough Materials like Stainless Steels



Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A127

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	Hrc			
P	1	Non-alloy steel	About 0.15% C Annealed	125		◎	◎	◎
	2		About 0.45% C Annealed	190	13	◎	◎	◎
	3		About 0.45% C Quenched & Tempered	250	25	○	○	○
	4		About 0.75% C Annealed	270	28			
	5		About 0.75% C Quenched & Tempered	300	32			
	6	Low alloy steel	Annealed	180	10	◎	◎	◎
	7		Quenched & Tempered	275	29	○	○	○
	8		Quenched & Tempered	300	32			
	9		Quenched & Tempered	350	38			
	10		High alloyed steel, and tool steel	Annealed	200	15		
	11	Quenched & Tempered	325	35				
M	12	Stainless steel	Ferritic / Martensitic Annealed	200	15	◎	◎	◎
	13		Martensitic Quenched & Tempered	240	23	◎	◎	◎
	14		Austenitic	180	10	◎	◎	◎
K	15	Grey cast iron	Pearlitic / ferritic	180	10			
	16		Pearlitic (Martensitic)	260	26			
	17	Nodular cast iron	Ferritic	160	3			
	18		Pearlitic	250	25			
	19		Ferritic	130				
20	Malleable cast iron	Pearlitic	230	21				
N	21	Aluminum-wrought alloy	Not Curable	60		◎	◎	◎
	22		Curable Hardened	100		◎	◎	◎
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable	75		○	○	○
	24		≤ 12% Si, Curable Hardened	90		○	○	○
	25		> 12% Si, Not Curable	130		○	○	○
	26		Cutting Alloys, PB>1%	110				
	27	Copper and Copper Alloys (Bronze / Brass)	CuZn, CuSnZn (Brass)	90				
	28		CuSn, lead-free copper and electrolytic copper	100				
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic					
	30		Rubber, Wood, etc.					
S	31	Heat Resistant Super Alloys	Fe Based Annealed	200	15			
	32		Cured	280	30			
	33		Annealed	250	25			
	34		Cured	350	38			
	35	Cast	320	34				
	36	Titanium Alloys	Pure Titanium	400 Rm				
	37		Alpha + Beta Alloys Hardened	1050 Rm		○	○	○
H	38	Hardened steel	Hardened	550	55			
	39		Hardened	630	60			
	40	Chilled Cast Iron	Cast	400	42			
41	Hardened Cast Iron	Hardened	550	55				

YG DREAM DRILLS - INOX

DH451 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

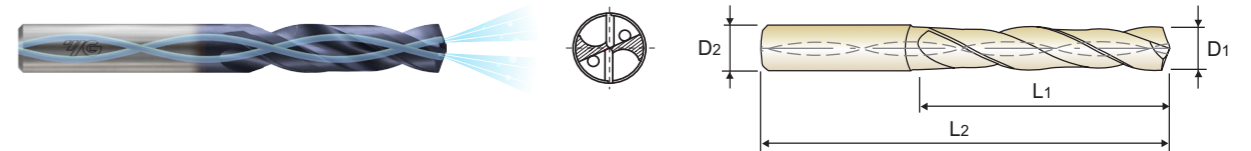
SHORT

- VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL
- Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série courte
- PUNTE ELICOIDALI IN MD, DREAM DRILLS - INOX (con fori di refrigerazione)

KURZ
COURTE
CORTA

- ▶ Special flute shape and geometry suitable for machining stainless steel
- ▶ Excellent chip evacuation from better surface treatment
- ▶ Point R-thinning achieves superior centering and chip curling
- ▶ TiAIN coating for better surface finishes and longer tool life

- ▶ Spezielle Nutenform und Geometrie für die Bearbeitung von rostfreiem Stahl
- ▶ Hervorragende Spanabfuhr durch bessere Oberflächenbehandlung
- ▶ Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung
- ▶ TiAIN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit



DIN 6537
CARBIDE
30°
h6
m7
140°
20 bar
TiAIN
p.A127
3 x D

Plain Shank
HYDRAULIC CHUCK
SHRINK FIT HOLDER
ER COLLET CHUCK

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	Unit : mm				
					TiAIN	D1	D2	L1	L2
DH451030	3.0	6	20	62	DH451054	5.4	6	28	66
DH451031	3.1	6	20	62	DH451055	5.5	6	28	66
DH451032	3.2	6	20	62	DH451056	5.6	6	28	66
DH451033	3.3	6	20	62	DH451057	5.7	6	28	66
DH451034	3.4	6	20	62	DH451058	5.8	6	28	66
DH451035	3.5	6	20	62	DH451059	5.9	6	28	66
DH451036	3.6	6	20	62	DH451060	6.0	6	28	66
DH451037	3.7	6	20	62	DH451061	6.1	8	34	79
DH451038	3.8	6	24	66	DH451062	6.2	8	34	79
DH451039	3.9	6	24	66	DH451063	6.3	8	34	79
DH451040	4.0	6	24	66	DH451064	6.4	8	34	79
DH451041	4.1	6	24	66	DH451065	6.5	8	34	79
DH451042	4.2	6	24	66	DH451066	6.6	8	34	79
DH451043	4.3	6	24	66	DH451067	6.7	8	34	79
DH451044	4.4	6	24	66	DH451068	6.8	8	34	79
DH451045	4.5	6	24	66	DH451069	6.9	8	34	79
DH451046	4.6	6	24	66	DH451070	7.0	8	34	79
DH451047	4.7	6	24	66	DH451071	7.1	8	41	79
DH451048	4.8	6	28	66	DH451072	7.2	8	41	79
DH451049	4.9	6	28	66	DH451073	7.3	8	41	79
DH451050	5.0	6	28	66	DH451074	7.4	8	41	79
DH451051	5.1	6	28	66	DH451075	7.5	8	41	79
DH451052	5.2	6	28	66	DH451076	7.6	8	41	79
DH451053	5.3	6	28	66	DH451077	7.7	8	41	79

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323																				
Hrc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	○				◎	○			◎	◎	◎								

ISO	N							S							H						
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron				
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323																					
Hrc	15	30	25	38	34						15	30	25	38	34	400Rm	1050Rm	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	○	○	○												○				

HSS

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -PRO

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

GENERAL CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

SUPER-GP DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

REAMERS

COUNTER SINKS

COUNTER BORES

TECHNICAL DATA

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

SHORT

- VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL
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DIN 6537 CARBIDE 30° h6 m7 140° 20 bar TiAIN p.A127 3 x D

Plain Shank
 HYDRAULIC CHUCK
 SHRINK FIT HOLDER
 ER COLLET CHUCK

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
TiAIN				
DH451078	7.8	8	41	79
DH451079	7.9	8	41	79
DH451080	8.0	8	41	79
DH451081	8.1	10	47	89
DH451082	8.2	10	47	89
DH451083	8.3	10	47	89
DH451084	8.4	10	47	89
DH451085	8.5	10	47	89
DH451086	8.6	10	47	89
DH451087	8.7	10	47	89
DH451088	8.8	10	47	89
DH451089	8.9	10	47	89
DH451090	9.0	10	47	89
DH451091	9.1	10	47	89
DH451092	9.2	10	47	89
DH451093	9.3	10	47	89
DH451094	9.4	10	47	89
DH451095	9.5	10	47	89
DH451096	9.6	10	47	89
DH451097	9.7	10	47	89
DH451098	9.8	10	47	89
DH451099	9.9	10	47	89
DH451100	10.0	10	47	89
DH451101	10.1	12	55	102

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
TiAIN				
DH451102	10.2	12	55	102
DH451103	10.3	12	55	102
DH451104	10.4	12	55	102
DH451105	10.5	12	55	102
DH451106	10.6	12	55	102
DH451107	10.7	12	55	102
DH451108	10.8	12	55	102
DH451109	10.9	12	55	102
DH451110	11.0	12	55	102
DH451111	11.1	12	55	102
DH451112	11.2	12	55	102
DH451113	11.3	12	55	102
DH451114	11.4	12	55	102
DH451115	11.5	12	55	102
DH451116	11.6	12	55	102
DH451117	11.7	12	55	102
DH451118	11.8	12	55	102
DH451119	11.9	12	55	102
DH451120	12.0	12	55	102
DH451125	12.5	14	60	107
DH451130	13.0	14	60	107
DH451135	13.5	14	60	107
DH451140	14.0	14	60	107
DH451145	14.5	16	65	115

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○	○	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	55	60	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

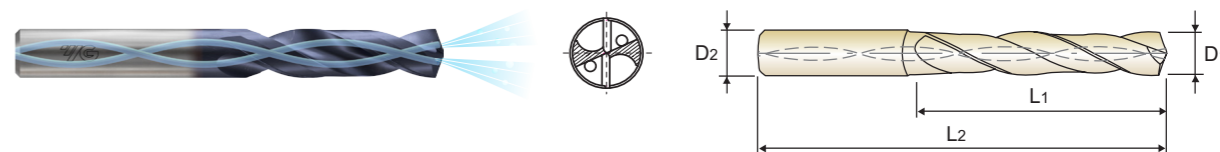
CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

SHORT

- VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL
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DIN 6537 CARBIDE 30° h6 m7 140° 20 bar TiAIN p.A127 3 x D

Plain Shank
 HYDRAULIC CHUCK
 SHRINK FIT HOLDER
 ER COLLET CHUCK

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
TiAIN				
DH451150	15.0	16	65	115
DH451155	15.5	16	65	115
DH451160	16.0	16	65	115
DH451165	16.5	18	73	123
DH451170	17.0	18	73	123
DH451175	17.5	18	73	123

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
TiAIN				
DH451180	18.0	18	73	123
DH451185	18.5	20	79	131
DH451190	19.0	20	79	131
DH451195	19.5	20	79	131
DH451200	20.0	20	79	131

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

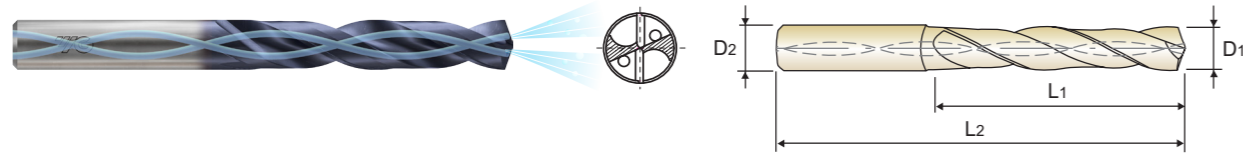
ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○	○	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	55	60	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES LONG

- VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL LANG
- Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série longue LONGUE
- PUNTE ELICOIDALI IN MD, DREAM DRILLS - INOX (con fori di refrigerazione) LUNGA

- Special flute shape and geometry suitable for machining stainless steel
- Excellent chip evacuation from better surface treatment
- Point R-thinning achieves superior centering and chip curling
- TiAlN coating for better surface finishes and longer tool life
- Spezielle Nutenform und Geometrie für die Bearbeitung von rostfreiem Stahl
- Hervorragende Spanabfuhr durch bessere Oberflächenbehandlung
- Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung
- TiAlN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar TiAlN p.A127 5 x D

Plain Shank
 HYDRAULIC CHUCK
 SHRINK FIT HOLDER
 ER COLLET CHUCK

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH452010	1.0	3	8	55	DH452034	3.4	6	28	66
DH452011	1.1	3	12	55	DH452035	3.5	6	28	66
DH452012	1.2	3	12	55	DH452036	3.6	6	28	66
DH452013	1.3	3	12	55	DH452037	3.7	6	28	66
DH452014	1.4	3	12	55	DH452038	3.8	6	36	74
DH452015	1.5	3	16	55	DH452039	3.9	6	36	74
DH452016	1.6	3	16	55	DH452040	4.0	6	36	74
DH452017	1.7	3	16	55	DH452041	4.1	6	36	74
DH452018	1.8	3	16	55	DH452042	4.2	6	36	74
DH452019	1.9	3	16	55	DH452043	4.3	6	36	74
DH452020	2.0	4	21	57	DH452044	4.4	6	36	74
DH452021	2.1	4	21	57	DH452045	4.5	6	36	74
DH452022	2.2	4	21	57	DH452046	4.6	6	36	74
DH452023	2.3	4	21	57	DH452047	4.7	6	36	74
DH452024	2.4	4	21	57	DH452048	4.8	6	44	82
DH452025	2.5	4	21	57	DH452049	4.9	6	44	82
DH452026	2.6	4	21	57	DH452050	5.0	6	44	82
DH452027	2.7	4	21	57	DH452051	5.1	6	44	82
DH452028	2.8	4	21	57	DH452052	5.2	6	44	82
DH452029	2.9	4	21	57	DH452053	5.3	6	44	82
DH452030	3.0	6	28	66	DH452054	5.4	6	44	82
DH452031	3.1	6	28	66	DH452055	5.5	6	44	82
DH452032	3.2	6	28	66	DH452056	5.6	6	44	82
DH452033	3.3	6	28	66	DH452057	5.7	6	44	82

► Other shank types are available on your request. ► NEXT PAGE

◎ : Excellent ○ : Good

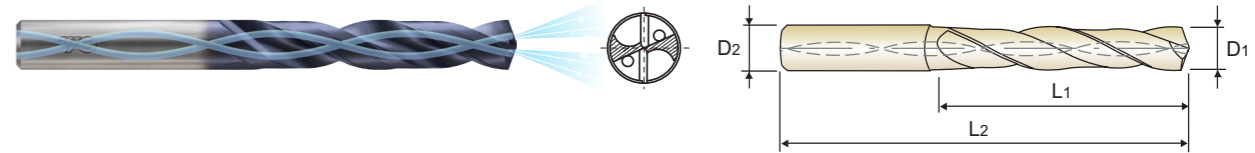
ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES LONG

- VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL LANG
- Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série longue LONGUE
- PUNTE ELICOIDALI IN MD, DREAM DRILLS - INOX (con fori di refrigerazione) LUNGA

- Special flute shape and geometry suitable for machining stainless steel
- Excellent chip evacuation from better surface treatment
- Point R-thinning achieves superior centering and chip curling
- TiAlN coating for better surface finishes and longer tool life
- Spezielle Nutenform und Geometrie für die Bearbeitung von rostfreiem Stahl
- Hervorragende Spanabfuhr durch bessere Oberflächenbehandlung
- Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung
- TiAlN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar TiAlN p.A127 5 x D

Plain Shank
 HYDRAULIC CHUCK
 SHRINK FIT HOLDER
 ER COLLET CHUCK

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
DH452058	5.8	6	44	82	DH452082	8.2	10	61	103
DH452059	5.9	6	44	82	DH452083	8.3	10	61	103
DH452060	6.0	6	44	82	DH452084	8.4	10	61	103
DH452061	6.1	8	53	91	DH452085	8.5	10	61	103
DH452062	6.2	8	53	91	DH452086	8.6	10	61	103
DH452063	6.3	8	53	91	DH452087	8.7	10	61	103
DH452064	6.4	8	53	91	DH452088	8.8	10	61	103
DH452065	6.5	8	53	91	DH452089	8.9	10	61	103
DH452066	6.6	8	53	91	DH452090	9.0	10	61	103
DH452067	6.7	8	53	91	DH452091	9.1	10	61	103
DH452068	6.8	8	53	91	DH452092	9.2	10	61	103
DH452069	6.9	8	53	91	DH452093	9.3	10	61	103
DH452070	7.0	8	53	91	DH452094	9.4	10	61	103
DH452071	7.1	8	53	91	DH452095	9.5	10	61	103
DH452072	7.2	8	53	91	DH452096	9.6	10	61	103
DH452073	7.3	8	53	91	DH452097	9.7	10	61	103
DH452074	7.4	8	53	91	DH452098	9.8	10	61	103
DH452075	7.5	8	53	91	DH452099	9.9	10	61	103
DH452076	7.6	8	53	91	DH452100	10.0	10	61	103
DH452077	7.7	8	53	91	DH452101	10.1	12	71	118
DH452078	7.8	8	53	91	DH452102	10.2	12	71	118
DH452079	7.9	8	53	91	DH452103	10.3	12	71	118
DH452080	8.0	8	53	91	DH452104	10.4	12	71	118
DH452081	8.1	10	61	103	DH452105	10.5	12	71	118

► Other shank types are available on your request. ► NEXT PAGE

◎ : Excellent ○ : Good

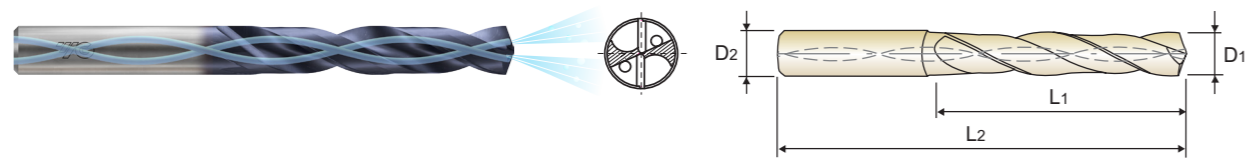
ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES **LONG**

- VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL **LANG**
- Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série longue **LONGUE**
- PUNTE ELICOIDALI IN MD, DREAM DRILLS - INOX (con fori di refrigerazione) **LUNGA**

- ▶ Special flute shape and geometry suitable for machining stainless steel
 - ▶ Excellent chip evacuation from better surface treatment
 - ▶ Point R-thinning achieves superior centering and chip curling
 - ▶ TiAIN coating for better surface finishes and longer tool life
- ▶ Spezielle Nutenform und Geometrie für die Bearbeitung von rostfreiem Stahl
 - ▶ Hervorragende Spanabfuhr durch bessere Oberflächenbehandlung
 - ▶ Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung
 - ▶ TiAIN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar TiAIN p.A127 5 x D

Plain Shank
 HYDRAULIC CHUCK
 SHRINK FIT HOLDER
 ER COLLET CHUCK

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
TiAIN				
DH452106	10.6	12	71	118
DH452107	10.7	12	71	118
DH452108	10.8	12	71	118
DH452109	10.9	12	71	118
DH452110	11.0	12	71	118
DH452111	11.1	12	71	118
DH452112	11.2	12	71	118
DH452113	11.3	12	71	118
DH452114	11.4	12	71	118
DH452115	11.5	12	71	118
DH452116	11.6	12	71	118
DH452117	11.7	12	71	118
DH452118	11.8	12	71	118
DH452119	11.9	12	71	118
DH452120	12.0	12	71	118
DH452125	12.5	14	77	124
DH452130	13.0	14	77	124
DH452135	13.5	14	77	124
DH452140	14.0	14	77	124
DH452145	14.5	16	83	133
DH452150	15.0	16	83	133
DH452155	15.5	16	83	133
DH452160	16.0	16	83	133
DH452165	16.5	18	93	143

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
TiAIN				
DH452170	17.0	18	93	143
DH452175	17.5	18	93	143
DH452180	18.0	18	93	143
DH452185	18.5	20	101	153
DH452190	19.0	20	101	153
DH452195	19.5	20	101	153
DH452200	20.0	20	101	153

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

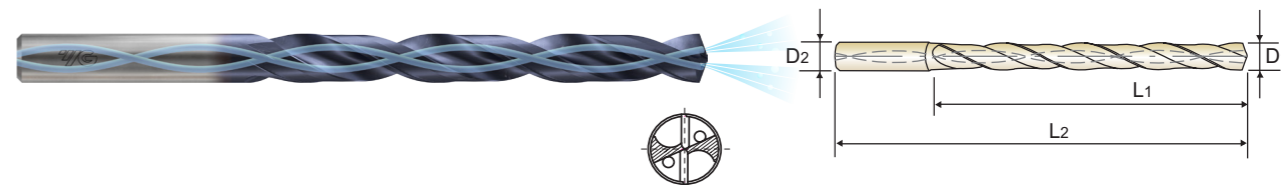
ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	N					S										H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES **EXTRA LONG**

- VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL **ÜBERLANG**
- Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série extra-longue **EXTRA-LONGUE**
- PUNTE ELICOIDALI IN MD, DREAM DRILLS - INOX (con fori di refrigerazione) **EXTRA LUNGA**

- ▶ Special flute shape and geometry suitable for machining stainless steel
 - ▶ Excellent chip evacuation from better surface treatment
 - ▶ Point R-thinning achieves superior centering and chip curling
 - ▶ TiAIN coating for better surface finishes and longer tool life
- ▶ Spezielle Nutenform und Geometrie für die Bearbeitung von rostfreiem Stahl
 - ▶ Hervorragende Spanabfuhr durch bessere Oberflächenbehandlung
 - ▶ Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung
 - ▶ TiAIN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar TiAIN p.A127 8 x D

Plain Shank
 HYDRAULIC CHUCK
 SHRINK FIT HOLDER
 ER COLLET CHUCK

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
TiAIN				
DH453030	3.0	6	34	72
DH453031	3.1	6	34	72
DH453032	3.2	6	34	72
DH453033	3.3	6	34	72
DH453034	3.4	6	34	72
DH453035	3.5	6	34	72
DH453036	3.6	6	34	72
DH453037	3.7	6	34	72
DH453038	3.8	6	43	81
DH453039	3.9	6	43	81
DH453040	4.0	6	43	81
DH453041	4.1	6	43	81
DH453042	4.2	6	43	81
DH453043	4.3	6	43	81
DH453044	4.4	6	43	81
DH453045	4.5	6	43	81
DH453046	4.6	6	43	81
DH453047	4.7	6	43	81
DH453048	4.8	6	57	95
DH453049	4.9	6	57	95
DH453050	5.0	6	57	95
DH453051	5.1	6	57	95
DH453052	5.2	6	57	95
DH453053	5.3	6	57	95

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
TiAIN				
DH453054	5.4	6	57	95
DH453055	5.5	6	57	95
DH453056	5.6	6	57	95
DH453057	5.7	6	57	95
DH453058	5.8	6	57	95
DH453059	5.9	6	57	95
DH453060	6.0	6	57	95
DH453061	6.1	8	76	114
DH453062	6.2	8	76	114
DH453063	6.3	8	76	114
DH453064	6.4	8	76	114
DH453065	6.5	8	76	114
DH453066	6.6	8	76	114
DH453067	6.7	8	76	114
DH453068	6.8	8	76	114
DH453069	6.9	8	76	114
DH453070	7.0	8	76	114
DH453071	7.1	8	76	114
DH453072	7.2	8	76	114
DH453073	7.3	8	76	114
DH453074	7.4	8	76	114
DH453075	7.5	8	76	114
DH453076	7.6	8	76	114
DH453077	7.7	8	76	114

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	N					S										H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

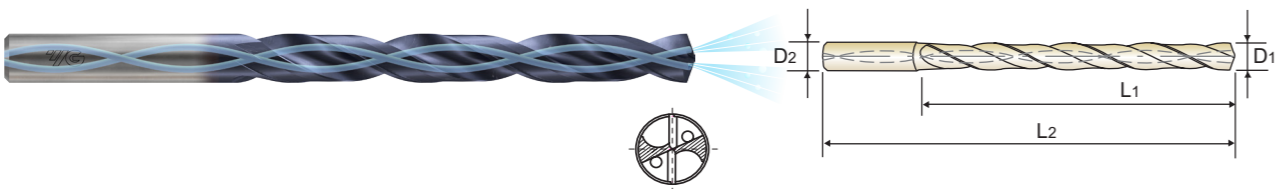
YMG DREAM DRILLS - INOX

DH453 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES EXTRA LONG

● VOLLHARTMETALL DREAM SPIRALBOHRER - INOX mit KÜHLKANAL **ÜBERLANG**
● Forets DREAM DRILLS carbure pour INOX, avec arrosage central, série extra-longue **EXTRA-LONGUE**
● PUNTE ELICOIDALI IN MD, DREAM DRILLS - INOX (con fori di refrigerazione) **EXTRA LUNGA**

- ▶ Special flute shape and geometry suitable for machining stainless steel
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- ▶ Vorzügliche Zentrierung und Spanbruch durch die R-Ausspitzung
- ▶ TiAlN-Beschichtung für bessere Oberflächengüte der Bohrung und längere Standzeit



DIN 6537 CARBIDE 30° h6 m7 140° 20 bar TiAlN p.A127 8 x D
 Plain Shank HYDRAULIC CHUCK SHRINK FIT HOLDER ER COLLET CHUCK Recommended ToolHolder

EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
DH453078	7.8	8	76	114	DH453102	10.2	12	114	162
DH453079	7.9	8	76	114	DH453103	10.3	12	114	162
DH453080	8.0	8	76	114	DH453104	10.4	12	114	162
DH453081	8.1	10	95	142	DH453105	10.5	12	114	162
DH453082	8.2	10	95	142	DH453106	10.6	12	114	162
DH453083	8.3	10	95	142	DH453107	10.7	12	114	162
DH453084	8.4	10	95	142	DH453108	10.8	12	114	162
DH453085	8.5	10	95	142	DH453109	10.9	12	114	162
DH453086	8.6	10	95	142	DH453110	11.0	12	114	162
DH453087	8.7	10	95	142	DH453111	11.1	12	114	162
DH453088	8.8	10	95	142	DH453112	11.2	12	114	162
DH453089	8.9	10	95	142	DH453113	11.3	12	114	162
DH453090	9.0	10	95	142	DH453114	11.4	12	114	162
DH453091	9.1	10	95	142	DH453115	11.5	12	114	162
DH453092	9.2	10	95	142	DH453116	11.6	12	114	162
DH453093	9.3	10	95	142	DH453117	11.7	12	114	162
DH453094	9.4	10	95	142	DH453118	11.8	12	114	162
DH453095	9.5	10	95	142	DH453119	11.9	12	114	162
DH453096	9.6	10	95	142	DH453120	12.0	12	114	162
DH453097	9.7	10	95	142	DH453125	12.5	14	133	178
DH453098	9.8	10	95	142	DH453130	13.0	14	133	178
DH453099	9.9	10	95	142	DH453135	13.5	14	133	178
DH453100	10.0	10	95	142	DH453140	14.0	14	133	178
DH453101	10.1	12	114	162					

▶ Other shank types are available on your request.

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC																				
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N										S							H			
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC																					
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	55	60	42	55
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

YMG DREAM DRILLS - INOX

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

DH451, DH452, DH453 SERIES with COOLANT HOLES

Vc = m/min, RPM = rev./min, FEED = mm/rev.

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)		Vc	Parameter	Drill Diameter (mm)			
					1.0	2.0			3.0	4.0	5.0	6.0
P	2	Non-alloy steel	70	RPM	22280	11140	100	RPM	10610	7960	6370	5310
			FEED	0.02-0.04	0.04-0.06	FEED		0.04-0.10	0.06-0.12	0.12-0.18	0.14-0.20	
	3	Low alloy steel	70	RPM	22280	11140	100	RPM	10610	7960	6370	5310
			FEED	0.02-0.04	0.04-0.06	FEED	0.04-0.10	0.06-0.12	0.12-0.18	0.14-0.20		
6	Low alloy steel	70	RPM	22280	11140	100	RPM	10610	7960	6370	5310	
		FEED	0.02-0.04	0.04-0.06	FEED	0.04-0.10	0.06-0.12	0.12-0.18	0.14-0.20			
7	Low alloy steel	50	RPM	15920	7960	70	RPM	7430	5570	4460	3710	
		FEED	0.02-0.04	0.04-0.06	FEED	0.04-0.10	0.06-0.12	0.12-0.18	0.14-0.20			
M	12	Stainless steel	40	RPM	12730	6370	50	RPM	5310	3980	3180	2650
			FEED	0.02-0.04	0.02-0.04	FEED		0.03-0.05	0.05-0.09	0.07-0.11	0.08-0.12	
			25	RPM	7960	3980		40	RPM	4240	3180	2550
13	Stainless steel	FEED	0.02-0.04	0.02-0.04	FEED	0.03-0.05	0.05-0.09	0.07-0.11	0.08-0.12			
		45	RPM	14320	7160	60	RPM	6370	4770	3820	3180	
		FEED	0.02-0.04	0.02-0.04	FEED		0.04-0.06	0.06-0.10	0.08-0.12	0.09-0.13		
21	Aluminum-wrought alloy	130	RPM	41380	20690		200	RPM	21220	15920	12730	10610
		FEED	0.04-0.10	0.08-0.14	FEED	0.14-0.20		0.19-0.25	0.20-0.26	0.22-0.28		
		130	RPM	41380	20690	200		RPM	21220	15920	12730	10610
22	Aluminum-wrought alloy	FEED	0.04-0.10	0.08-0.14	FEED	0.14-0.20	0.19-0.25	0.20-0.26	0.22-0.28			
		110	RPM	35010	17510	180	RPM	19100	14320	11460	9550	
		FEED	0.04-0.10	0.08-0.14	FEED		0.14-0.20	0.19-0.25	0.20-0.26	0.22-0.28		
23	Aluminum-cast, alloyed	110	RPM	35010	17510		180	RPM	19100	14320	11460	9550
		FEED	0.04-0.10	0.08-0.14	FEED	0.14-0.20		0.19-0.25	0.20-0.26	0.22-0.28		
		90	RPM	28650	14320	150		RPM	15920	11940	9550	7960
FEED	0.04-0.08	0.06-0.10	FEED	0.12-0.18	0.16-0.22		0.17-0.23	0.19-0.25				
37	Titanium Alloys	25	RPM	7960	3980		40	RPM	4240	3180	2550	2120
		FEED	0.01-0.03	0.01-0.03	FEED	0.02-0.04		0.04-0.08	0.06-0.10	0.07-0.11		

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)							
					8.0	10.0	12.0	14.0	16.0	18.0	20.0	
P	2	Non-alloy steel	100	RPM	3980	3180	2650	2270	1990	1770	1590	
			FEED	0.16-0.22	0.18-0.24	0.19-0.27	0.21-0.39	0.23-0.31	0.26-0.36	0.28-0.38		
	3	Low alloy steel	100	RPM	3980	3180	2650	2270	1990	1770	1590	
			FEED	0.16-0.22	0.18-0.24	0.19-0.27	0.21-0.39	0.23-0.31	0.26-0.36	0.28-0.38		
6	Low alloy steel	100	RPM	3980	3180	2650	2270	1990	1770	1590		
		FEED	0.16-0.22	0.18-0.24	0.19-0.27	0.21-0.39	0.23-0.31	0.26-0.36	0.28-0.38			
7	Low alloy steel	70	RPM	2790	2230	1860	1590	1390	1240	1110		
		FEED	0.16-0.22	0.18-0.24	0.19-0.27	0.21-0.39	0.23-0.31	0.26-0.36	0.28-0.38			
M	12	Stainless steel	50	RPM	1990	1590	1330	1140	990	880	800	
			FEED	0.09-0.13	0.10-0.15	0.11-0.16	0.12-0.17	0.13-0.18	0.14-0.19	0.15-0.20		
			40	RPM	1590	1270	1060	910	800	710	640	
13	Stainless steel	FEED	0.09-0.13	0.10-0.15	0.11-0.16	0.12-0.17	0.13-0.18	0.14-0.19	0.15-0.20			
		60	RPM	2390	1910	1590	1360	1190	1060	950		
		FEED	0.10-0.14	0.11-0.16	0.12-0.17	0.13-0.18	0.14-0.19	0.15-0.20	0.16-0.21			
21	Aluminum-wrought alloy	200	RPM	7960	6370	5310	4550	3980	3540	3180		
		FEED	0.24-0.30	0.26-0.32	0.28-0.34	0.30-0.36	0.32-0.38	0.33-0.43	0.35-0.45			
		200	RPM	7960	6370	5310	4550	3980	3540	3180		
22	Aluminum-wrought alloy	FEED	0.24-0.30	0.26-0.32	0.28-0.34	0.30-0.36	0.32-0.38	0.33-0.43	0.35-0.45			
		180	RPM	7160	5730	4770	4090	3580	3180	2860		
		FEED	0.24-0.30	0.26-0.32	0.28-0.34	0.30-0.36	0.32-0.38	0.33-0.43	0.35-0.45			
23	Aluminum-cast, alloyed	180	RPM	7160	5730	4770	4090	3580	3180	2860		
		FEED	0.24-0.30	0.26-0.32	0.28-0.34	0.30-0.36	0.32-0.38	0.33-0.43	0.35-0.45			
		150	RPM	5970	4770	3980	3410	2980	2650	2390		
37	Titanium Alloys	40	RPM	1590	1270	1060	910	800	710	640		
		FEED	0.08-0.12	0.09-0.14	0.10-0.15	0.11-0.16	0.12-0.17	0.13-0.18	0.14-0.19			

▶ Recommend to reduce the feed rate as following
Feed 100% : DH451(3xD), DH452(5xD) **Feed 85%** : DH453(8xD)